

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____					
Misidentified ☐	Past Due ☐						

Work Order ID 155644

Tuesday, January 17, 2017 11:31:58 AM

155644

Page 2

Item ID: D130-700-011

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: EC130 Bearpaws

Start Date: 1/10/2017 Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/20/2017 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

180

Packaging

Packaging

0.00

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D130-700-011

LOCATION: FG012DAS
28
9-80DAS
27
9-89

FEB 09 2017

190

190

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.02

DAS
21
9-89

1702-10



17-2-10

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Date :		Step #:		QTY Effective :			MRB (QS1042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
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Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
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Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____					
Misidentified ☐	Past Due ☐						

Picklist Print

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Page 1

Work Order ID: 155644

155644

Parent Item: D130-700-011

D130-700-011

Parent Item Name: EC130 Bearpaws

Start Date: 1/10/2017

Required Date: 1/20/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN4-12A

Purchased

No

170

Each

186.0000

4

4

AN4-12A

Bolt

**

Location

Loc Qty

Loc Code

FG

10

120423

10

ST344

176

m135704

56

m136579

120

AN4-15A

Purchased

No

170

Each

793.0000

8

8

AN4-15A

Bolt

**

Location

Loc Qty

Loc Code

GA

10

120449

10

over003

645

m135859

645

ST343

138

m135859

138

D2182B060

Manufactured

No

170

Each

80.0000

4

4

D2182B060

Clamp Cushion Black 6.0 "Long

**

Location

Loc Qty

Loc Code

FG

15

93429

15

ST639

65

151626

15

152041

50

68-6
9-89
SVC 6
9-89
DAS 28
FEB 09 2017

68-6
9-89
SVC 6
9-89
DAS 28
FEB 09 2017

68-6
9-89
SVC 6
9-89
DAS 28
FEB 09 2017

DAS
27
9-89

DAS
27
9-89

DAS
27
9-89

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Root Cause			FAULT CATEGORY			
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Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	
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Misidentified ☐	Past Due ☐					

Picklist Print

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Work Order ID: 155644

155644

Parent Item: D130-700-011

D130-700-011

Parent Item Name: EC130 Bearpaws

Start Date: 1/10/2017

Required Date: 1/20/2017

Start Qty: 1.00

Required Qty: 1.00

D2274 Manufactured No 170 Each 607.0000 **12** 12
D2274 **
 Radius Block

Location	Loc Qty	Loc Code
FG	12	
86855	12	
ST006	292	
150353	1	
151763	291	
ST012a	303	
152449	303	

D2519 Manufactured No 170 Each 35.0000 **4** 4
D2519 **
 Clamp

Location	Loc Qty	Loc Code
ST542	35	
150835	35	

D2529 Manufactured No 170 Each 979.0000 **12** 12
D2529 **
 Washer

Location	Loc Qty	Loc Code
ST008	979	
153945	79	
154187	100	
155073	800	

D3167-1 Manufactured No Each 0.0000 **2** 2
D3167-1 **
 Bearpaw

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Shop Packet Print

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Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Picklist Print

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Work Order ID: 155644

155644

Parent Item: D130-700-011

D130-700-011

Parent Item Name: EC130 Bearpaws

Start Date: 1/10/2017

Required Date: 1/20/2017

Start Qty: 1.00

Required Qty: 1.00

D3171-1 Manufactured No

170 Each 16.0000 4 4

D3171-1

Angle Bracket

**

FEB 09 2017

DAS 28 9-89

Location

Loc Qty

Loc Code

ST019

16

154846

16

4

MS21042L4

Purchased No

170 Each 1,873.000 12 12

MS21042L4

Nut

**

FEB 09 2017

DAS 28 9-89

Location

Loc Qty

Loc Code

FP001

18

m133363

18

136648

GA

192

m135058

192

OVER007

500

m136450

500

ST303

1163

m136182

500

m136295

663

NAS1149D0463J

Purchased No

170 Each 2,497.000 12 12

NAS1149D0463J

Washer

**

FEB 09 2017

DAS 28 9-89

Location

Loc Qty

Loc Code

GA

80

M134508

13

M135056

67

ST260a

1200

M136192

600

M136263

600

12

ST263

1217

M136044

217

M136406

1000

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Misidentified ☐	Past Due ☐																																																																

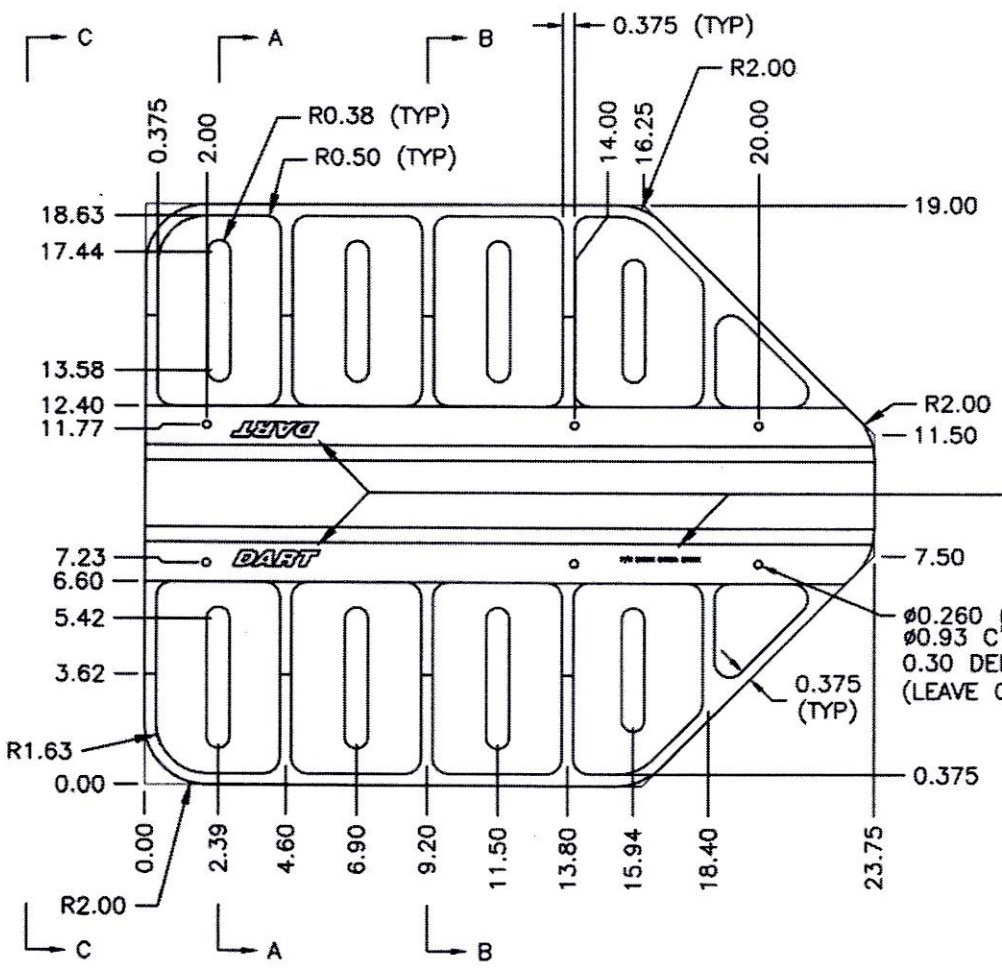
DART



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02.10.25

DESIGN		DRAWN BY		DART AEROSPACE LTD	
CHECKED		APPROVED		HANKESBURY, ONTARIO, CANADA	
DATE		TITLE		REV. A	
02.10.08		BEARPAW		SHEET 1 OF 2	
A		02.10.08		NEW ISSUE	
A1		02.12.17		5.80 WAS 5.50	
				SCALE	
				1:8	

ENGRAVE LOGO TO MAX DEPTH OF 0.012. ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010. (TYPICAL LOCATION AS ILLUSTRATED)



D3167-1

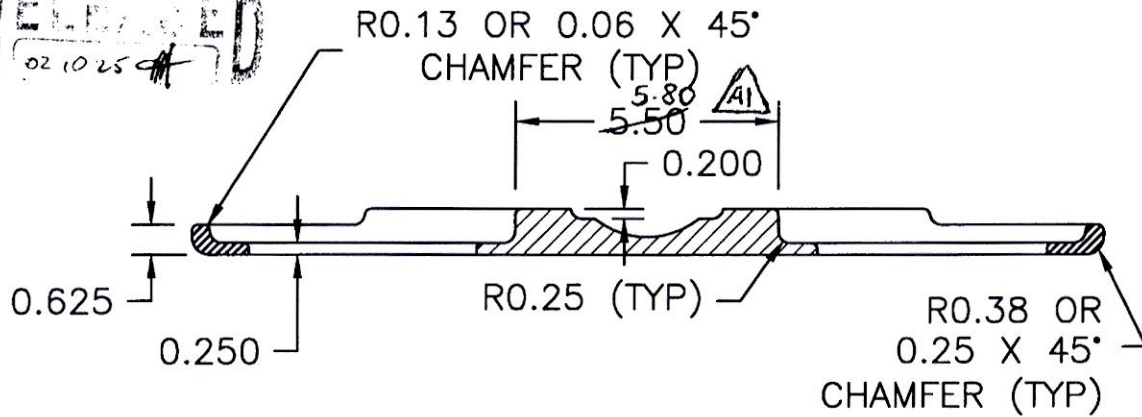
MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUSCEPT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 155644 MLJ
170119

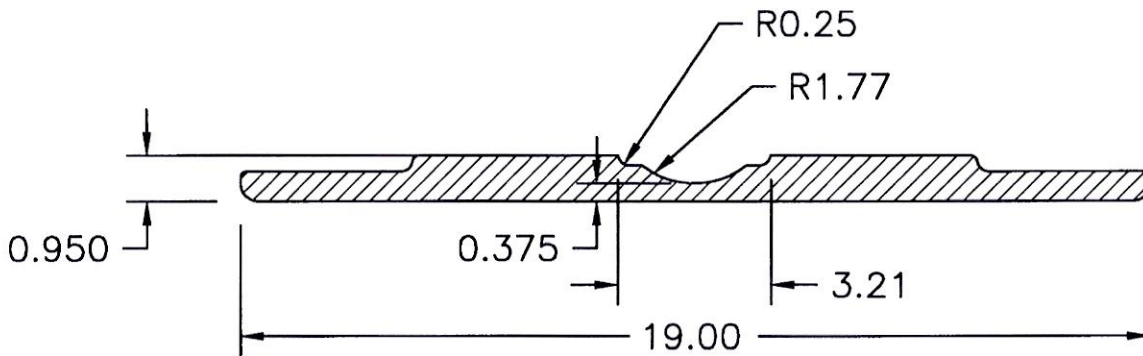


DESIGN 	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3167	REV. A SHEET 2 OF 2
DATE 02.10.08		TITLE BEARPAW	SCALE 1:4

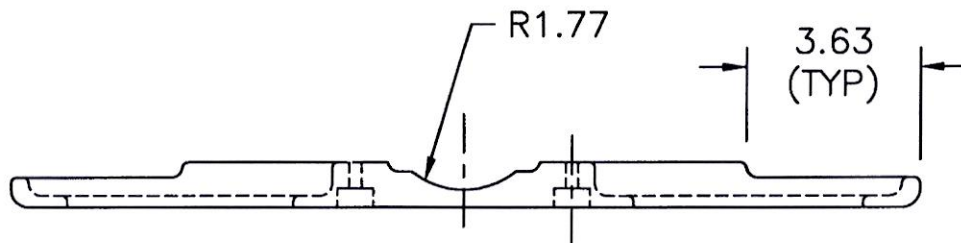
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02 10 25



SECTION A-A



SECTION B-B



SECTION C-C

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5 PARTS LIST

Qty -011	Qty -021	Part Number	Description
X		D130-700-011	BEARPAW INSTALLATION
	X	D130-700-021	WEARPLATE KIT
4		D2182B060	Rubber Cushion
12		D2274	Radius Block
12		D2529	Washer
4		D2519	Clamp
2		D3167-1	Bearpaw
4		D3171-1	Angle
	2	D3862-041	Wearplate
4	4	AN4-12A	Bolt
8	8	AN4-15A	Bolt
12	12	NAS1149D0463J	Washer
12	12	MS21042L4	Nut (or MS21042-4)